Work Order ID 69250

Thursday, May 05, 2011 12:42:24 PM

Item ID: D412-664-203TRN **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Crosstube Turning Detail

Start Date: 5/5/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/10/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-05-05 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D412-664-243	Rev E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	MORI SEIKI CNC LATHE LARGE	0.00				1			
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166 3- File transition lines smooth.								
110	QC1- Inspect dimensions to dimension sheet	0.00				1			
QC	**Memo**	0.00							
Quality Control									
120	MORI SEIKI CNC LATHE LARGE	0.00				1			
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA166 2- File transition lines smooth. 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stilus								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69250

Thursday, May 05, 2011 12:42:24 PM

Item ID: D412-664-203TRN **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Crosstube Turning Detail

Start Date: 5/5/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/10/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC1- Inspect dimensions to dimension sheet	0.00							
QC	**Memo**	0.00	129 11.5.7			1	0		
Quality Control									
140	QC8- Inspect parts - second check	0.00	ark 11/05/07						
QC	**Memo**	0.00				1	0		
Quality Control									
150	Crosstubes Chemical Conversion	0.00							
HandFXtube	**Memo**	0.00				BT 11.05.09 (x1)			
Hand Finishing Crosstubes									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69250

Thursday, May 05, 2011 12:42:24 PM

Item ID: D412-664-203TRN **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Crosstube Turning Detail

Start Date: 5/5/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/10/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00	DP		11-5-9				
QC Quality Control	**Memo**	0.00							
170		0.00							
Packaging	Packaging		DP		11-5-9				
Packaging	**Memo** Identify and stock in kanban rack Location: 46	0.00							
180	QC21- Final Inspection - Work Order Release	0.00							11/5/9
QC Quality Control	**Memo**	0.00							

11-05-9

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 05, 2011 12:42:21 PM

Work Order ID: 69250

Parent Item: D412-664-203TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 5/5/2011 **Required Date:** 5/10/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:eec
IPP Rev B 08.04.02 Removed polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129 Crosstube Material		Manufactured	No			120	Each	0.0000	1	1			

B651.71 X1 ark 11/05/07

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	**D412-664-243**	**CROSSTUBE ASSEMBLY (412 HIGH AFT)**
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#9230

DEO ATTACHED

RELEASED
2009 -10- 29

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6009-129
 FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
7) WEIGHT: 47.0 lbs (PER IIN-D212-664)
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

REV.	DESCRIPTION	BY	DATE
E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D412-664-243	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30		

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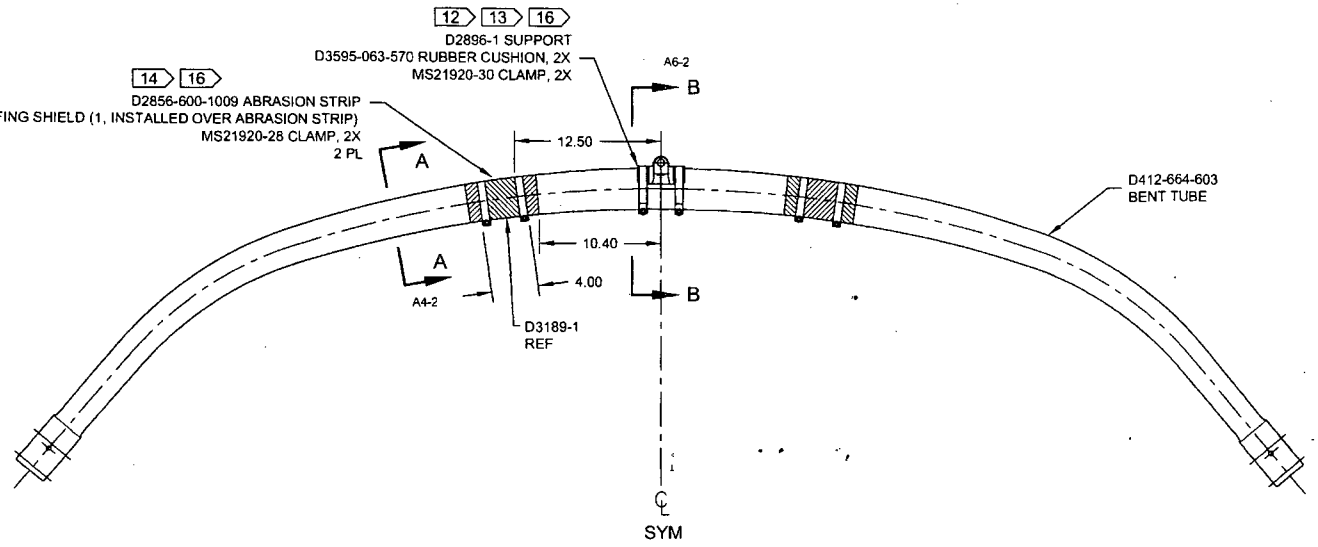
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

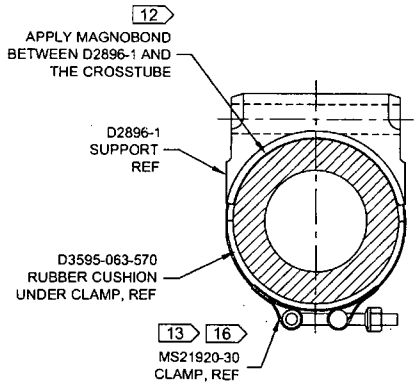
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

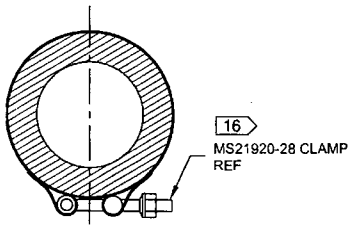
NOTE: Date & initial all entries



D212-664-243
ASSEMBLY DETAIL E



SECTION B-B D4-2
SCALE 4X



SECTION A-A C6-2
SCALE 4X

#69250

DEO ATTACHED

RELEASED
2009 -10- 29

DESIGN	PH	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D412-664-243	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30		

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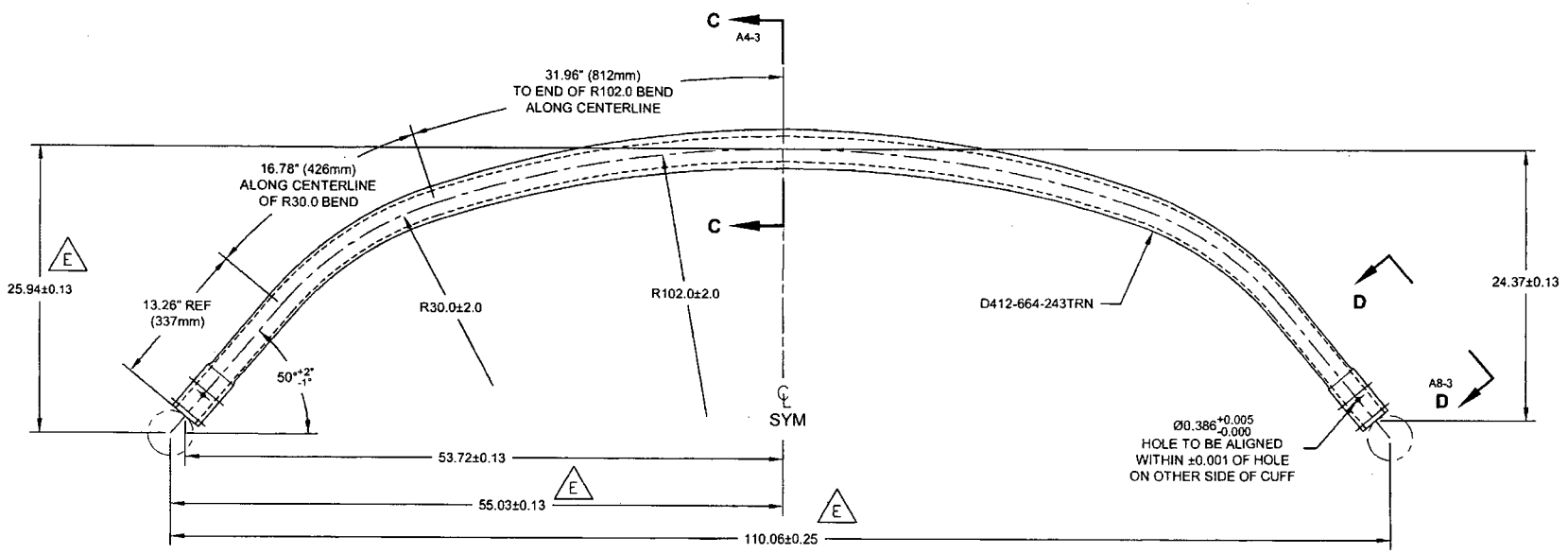
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

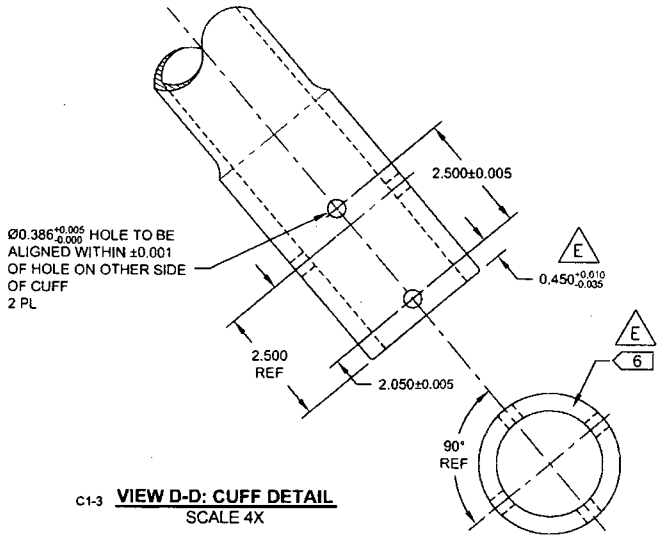
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

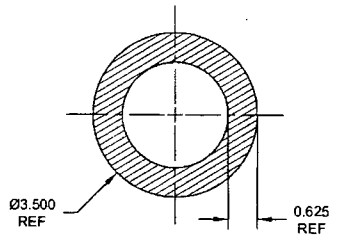
NOTE: Date & initial all entries



D412-664-603 10
BENDING AND DRILLING DETAIL E



C1-3 **VIEW D-D: CUFF DETAIL**
SCALE 4X



SECTION C-C D5-3
SCALE 4X

#6928

DEO ATTACHED

RELEASED
2009 -10- 29
MP

DESIGN	AH	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	AH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30		

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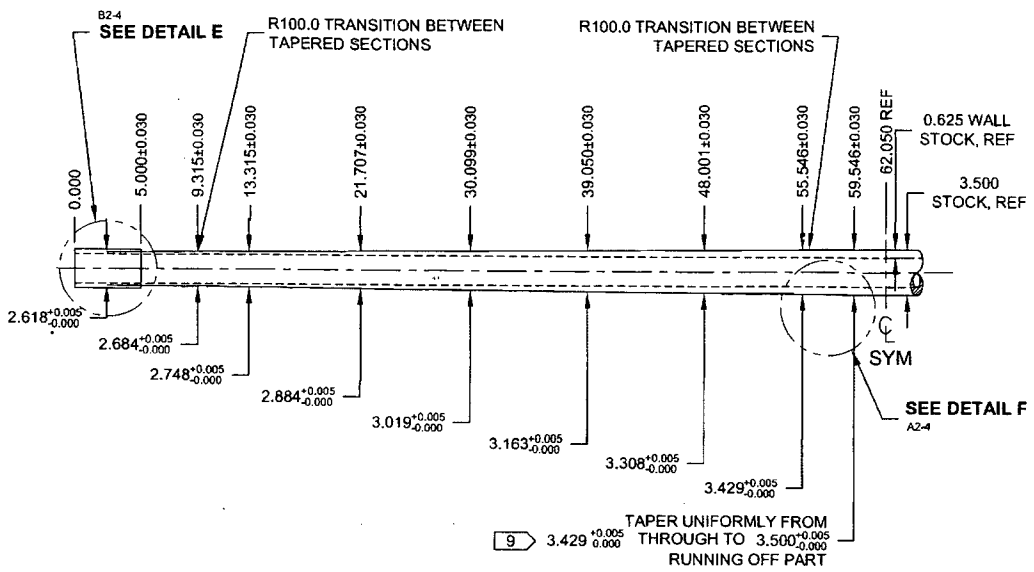
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

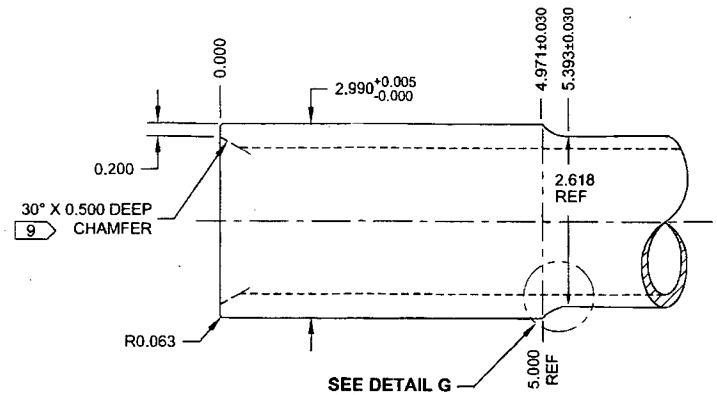
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

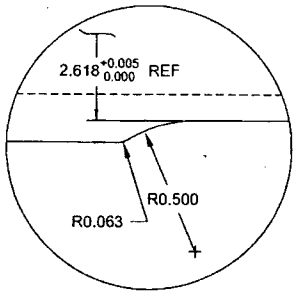
NOTE: Date & initial all entries



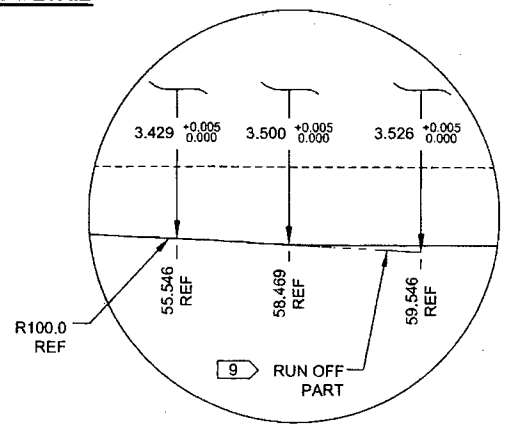


DETAIL E:
CROSSTUBE CUFF D8-4
SCALE 5X

D412-664-243TRN (E)
TURNING DETAIL



DETAIL G:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL F:
TAPER RUN-OFF C4-4
NOT TO SCALE

#69230

DEO ATTACHED

RELEASED
2009 -10- 29

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D412-664-243	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30		

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DRAWING NO.	TITLE REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)		D412-664-243-E-1	SHEET 1 OF 2	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.03.31	DATE 11/03.31	DATE 11.03.31	DATE 11/03.31	DATE 11.03.31

PURPOSE:
REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -243	Part Number	Description
6	0	D2856-600-1009	ABRASION STRIP

WAS:

6	2	D2856-600-1009	ABRASION STRIP

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA

14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

WAS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.

69250

RELEASED
2011-04-07

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

*H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DRAWING NO.	TITLE	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)			D412-664-243-E-1	SHEET 2 OF 2	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31

IS:

<16> <14>

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)
MS21920-28 CLAMP, 2X
2 PL

D412-664-603
BENT TUBE

2.00
1.00

WAS:

<14> <16>

D2856-600-1009 ABRASION STRIP
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)
MS21920-28 CLAMP, 2X
2 PL

D3189-1
REF

#6927

RELEASED
2011-04-07

D412-664-243
ASSEMBLY DETAIL

<2>

MASK AREA PRIOR TO PAINTING AND
APPLY CLEAR COAT AFTER PAINTING

2.00

℄
SYM

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69288
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 **Rev:** E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.684	✓		RQ.15	
	2.748	+0.005/-0.000	2.752	✓			
	2.884	+0.005/-0.000	2.887	✓			
	3.019	+0.005/-0.000	3.024	✓			
	3.163	+0.005/-0.000	3.166	✓			
	3.308	+0.005/-0.000	3.313	✓			
	3.429	+0.005/-0.000	3.432	✓			
	2.990	+0.005/-0.000	2.995	✓			
	2.618	+0.005/-0.000	2.622	✓			
	0.200	+/-0.010	.205	✓		RQ.02	
	R0.063	+/-0.010	R.063	✓			
	R0.500	+/-0.010	R.500	✓			
	4.971	+/-0.030	4.971	✓			
SIDE B	2.684	+0.005/-0.000	2.688	✓		RQ.15	
	2.748	+0.005/-0.000	2.752	✓			
	2.884	+0.005/-0.000	2.887	✓			
	3.019	+0.005/-0.000	3.024	✓			
	3.163	+0.005/-0.000	3.165	✓			
	3.308	+0.005/-0.000	3.313	✓			
	3.429	+0.005/-0.000	3.432	✓			
	2.990	+0.005/-0.000	2.995	✓			
	2.618	+0.005/-0.000	2.622	✓			
	0.200	+/-0.010	.205	✓		RQ.02	
	R0.063	+/-0.010	R.063	✓			
	R0.500	+/-0.010	R.500	✓			
	4.971	+/-0.030	4.971	✓			
	124.100	+/-0.020	124.120	✓		RQ.14	

Measured by:	RQ	Audited by:	CMK	Prototype Approval:	N/A
Date:	11.5.07	Date:	11/05/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	
D	10.02.02	Dimension 124.100 was 124.09	KJ	

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